

Work Order ID 59377

Wednesday, June 02, 2010 1:33:13 PM



Page 1

Item ID: D2512

Accept



Setup Start



Revision ID:

Item Name: Basket Lid 205/350

Stop



Start Date: 6/2/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 6/10/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: H

Date: 10-6-02 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2512

Rev E

100



Large Fab

Large Fab

Weld per dwg A/R S.S. rod Batch: 111079 0.00
Large Fab

Memo

0.00

1-Cut 3/4" x 3/4" square tubing as per Dwg D2512
2-Cut (4) D2236 From D3166-3
3-Drill holes in D2512-1 as per Dwg D2512 using Drill Jig DT8305
4-Weld as per Dwg D2512 using Welding Jig DT 9436
Deburr as required
INSTALL D2012-117 CLEVIS ONLY ON D130-701-041

SAD 10-06-17

① Rpl 10.06.23

110



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds 0.00

Memo

0.00

① PD 10.06.24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ CR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ A: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

130

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

1- Plug holes in D2581 and in D2327-1 bushing prior to Powdercoat

1ST COAT:

START TIME: 2:25

OVEN TEMPERATURE: 400°

FINISH TIME: 2:55

2ND COAT:

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

Sidolob24

PRESS WASH

BL 10-6-24.

MMH841

BL 10-6-24.

NAT smooth
Z

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 HandFinish Hand Finishing	HandFinishing Memo Wing Walk and Spray Paint black as per Dwg D2512 and QSI 005 4.4 Batch: <u>114430</u>	0.00 0.00				<u>M</u>	<u>10</u>	<u>06</u>	<u>25</u> ①
150 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							
160 Packaging Packaging	Identify as per dwg & Stock Location: <u>6A</u> <u>w/o 59375</u> Memo	0.00 0.00							

ES 10/06/25 @

ES 10/06/25 @

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Cust Item ID:

Required Date: 6/10/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CL 10/6/25

100025

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NOTE: Date & initial all entries

Picklist Print

Wednesday, June 02, 2010 1:33:19 PM

Page 1 13

Work Order ID: 59377



Parent Item: D2512



Parent Item Name: Basket Lid 205/350

Start Date: 6/2/2010

Required Date: 6/10/2010

Comments: Rev IPP:M03.01.31 AddedD2012-117forD130-701-041 KJ/RF

Start Qty: 1.00

Required Qty: 1.00

IPP Rev:N 06.04.05 Added level21

EC

IPP REV:N ADDED D3490-

1/-3 FOR D130-701-011/-043 10-04-20 JLM VERIFIED BY:DD

D4090-1 Manufactured No

Each 5.0000

1

1



Placard



Location

Loc Qty

Loc Code

ST112

5

57866

5

*** ONLY APPLICABLE ON D130-701-043/-011 -
IF NOT USED, PLEASE MARK N/A ***

D4090-3 Manufactured No

Each 5.0000

1

1



Placard



Location

Loc Qty

Loc Code

ST112

5

57865

5

*** ONLY APPLICABLE ON D130-701-043/-011 -
IF NOT USED, PLEASE MARK N/A ***

D2012-117 Manufactured No

100 Each

39.0000

2

2



Clevis



Location

Loc Qty

Loc Code

WA

39

52498

9

55729

30

*** ONLY APPLICABLE ON D130-701-041 -IF
NOT USED, PLEASE MARK N/A ***

D2232-1 Manufactured No

100 Each

36.0000

2

2



Basket Hinge



Location

Loc Qty

Loc Code

WA

36

55791

36

N/A for 350
use only on
C210/6/25

N/A

N/A

Cpl 10-06-21

(2)

W/O:		WORK ORDER CHANGES					
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Parent Item: D2512

Parent Item Name: Basket Lid 205/350

Comments: Rev IPP:M03.01.31 AddedD2012-117forD130-701-041 KJ/RF
IPP Rev:N 06.04.05 Added level21
EC
1-3 FOR D130-701-011/-043 10-04-20 JLM VERIFIED BY:DD

Start Date: 6/2/2010

Required Date: 6/10/2010

Start Qty: 1.00

Required Qty: 1.00

D2327-1

Manufactured No

100 Each

25.0000

2

2



Spacer Bushing

Location

Loc Qty

Loc Code

WA

25

52832

5

54658

20

D2506

Manufactured No

100 Each

5.0000

1

1



Label Plate

Location

Loc Qty

Loc Code

WA

5

57599

1

57836

4

D2581

Manufactured No

100 Each

73.0000

2

2



Mounting Bracket

Location

Loc Qty

Loc Code

ST

22

59121

22

WA

73

46086

2

51745

2

57185

1

58301

5

58687

20

59265

21

Cpl 10.06.21

Cpl 10.06.21

B59263 → ①

Cpl 10.06.21

②

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 3

13

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IPP Rev:N□06.04.05 Added level21
EC
1-3 FOR D130-701-011/-043 10-04-20 JLM VERIFIED BY:DD

Start Date: 6/2/2010

Required Date: 6/10/2010

Start Qty: 1.00

Required Qty: 1.00

✓ D3166-3 Manufactured No 100 Each 12.0528 1 1
Basket Hoop
SAD 10-06-17

Location	Loc Qty	Loc Code
WA	12.05282105	
55697	2.1053E-05	
56426	0.0528	
57504	6	
59266	6	

✓ M304EX0.75-16F Purchased No 100 sf 873.3295 18 18.94737
Expanded Metal Flat SS
SAD 10-06-17

Location	Loc Qty	Loc Code
MAT	873.3295	
114399	69.8283	
114594	55.4855	
114744	248.0157	
114809	500	

✓ M304TS0.750W.065 Purchased No 100 f 1,053.322 43.5804 45.87411
304 SQ Tube .75x.75x.065W
SAD 10-06-17

Location	Loc Qty	Loc Code
MAT	53.32232	
112398	0	
114482	53.32232	
WA	1000	
114520	1000	

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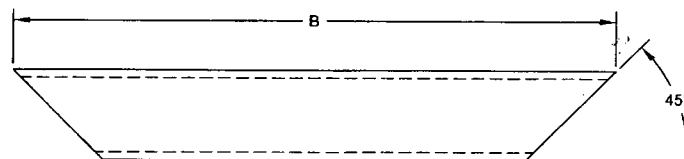
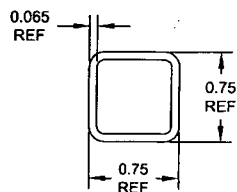
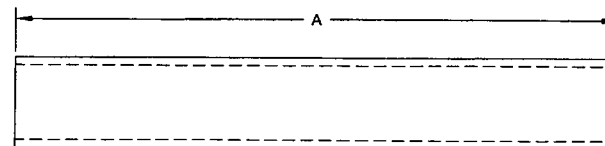
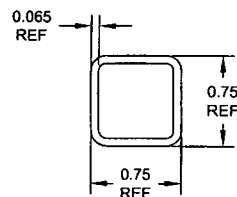
PARTS LIST FOR D2512 BASKET LID ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2512-1	2	—	25.50	RIB
D2512-3	2	—	95.30	RIB
D2512-5	6	30.84	—	RIB
D2512-7	3	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRACKET

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 59377

110-6-2

RELEASED
08-08-21/110



E

D2512-1/-3/-5/-7 NOTES:

- 1) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST

E	INCORPORATED D1 & D2. MATERIAL FOR -1, -3, -5, & -7 WAS 0.060 WALL. SHT 3 ZN C4 TOLERANCE REMOVED FROM 95.30 DIM. DRAWING TRANSFERRED TO "B" FORMAT AND UPDATED TO CURRENT STANDARDS. SHT 3 VIEWS INVERTED FOR CLARITY. SHT 2 MESH MATERIAL CALLOUT UPDATED.	AJS	08.06.17
D	CHANGE HINGE	CP	01.04.19
C	REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS. INCORP DEO 9074	DS	99.07.06
B	ADDED LATCH CHANNEL & LABEL PLATE	BW	96.05.24
A	NEW ISSUE	BW	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
DATE	08.06.17	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

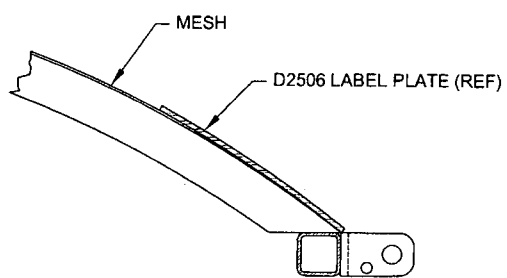
W/O:		WORK ORDER CHANGES					
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

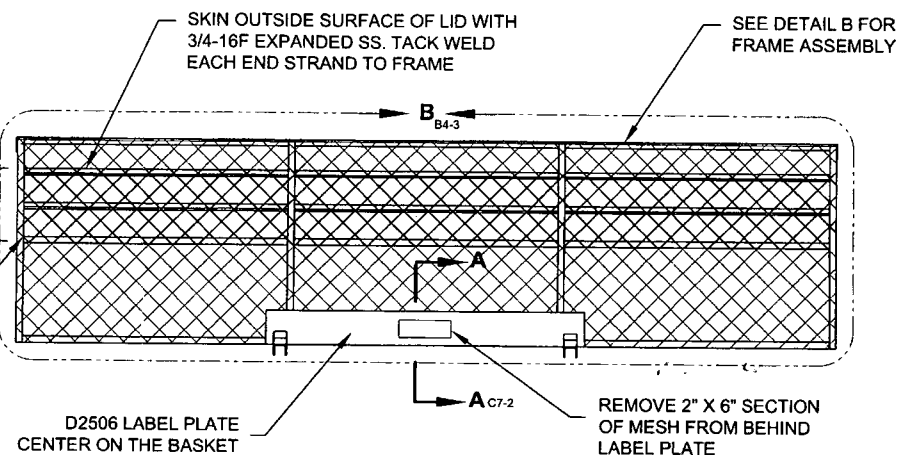
NOTE: Date & initial all entries



SECTION A-A_{B3-2}
(ROTATED 90° CCW)

FINISH THIS SECTION ALONG
ENTIRE LENGTH PER NOTE 3
AFTER POWDER COAT.

TACK WELD MESH TO FRAME
AT EVERY AVAILABLE LOCATION
IN AREA TO BE ANTI-SKIDDED



SEE DETAIL B FOR
FRAME ASSEMBLY

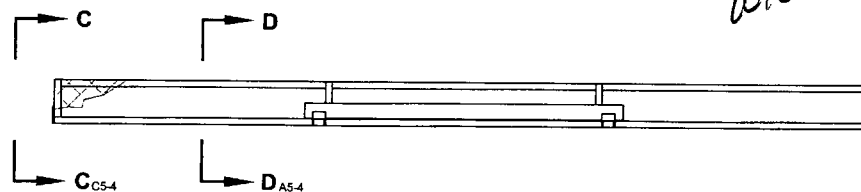
D2506 LABEL PLATE
CENTER ON THE BASKET

REMOVE 2" X 6" SECTION
OF MESH FROM BEHIND
LABEL PLATE



D2512 BASKET LID ASSEMBLY NOTES:

- 1) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
- 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) SPRAY PAINT BLACK INSIDE SURFACE
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: N/A
- 9) WELD PER DART QSI 004



RELEASED
08-05-21/17

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
DATE	08.06.17	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

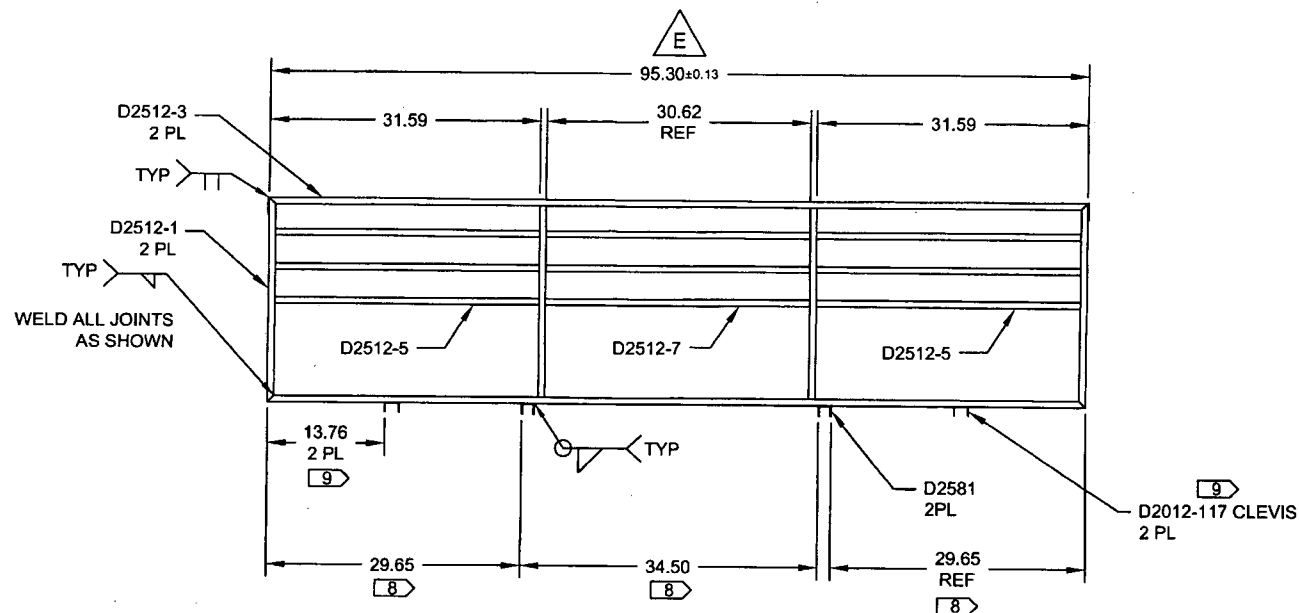
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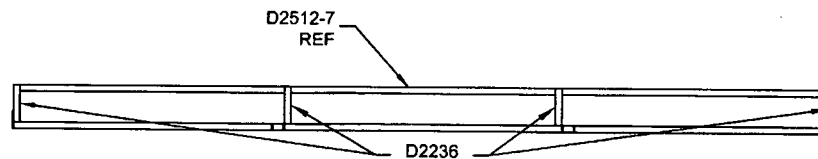
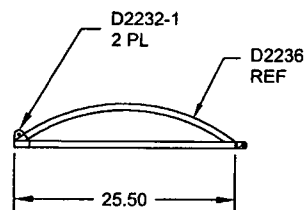
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DETAIL B C3-2
FRAMEWORK ONLY SHOWN FOR CLARITY



w/o 59377

RELEASED
08.06.17

NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) LOCATE IN CONJUNCTION WITH ADJACENT D2581 ON BASKET BASE ASSEMBLY
- 9) FOR D130-701-041 ONLY

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	J	DRAWING NO.	REV. E
MFG. APPR.	AS	D2512	SHEET 3 OF 4
APPROVED	AP	TITLE	SCALE
DE APPR.	TH	BASKET LID ASSEMBLY (350/212)	NTS
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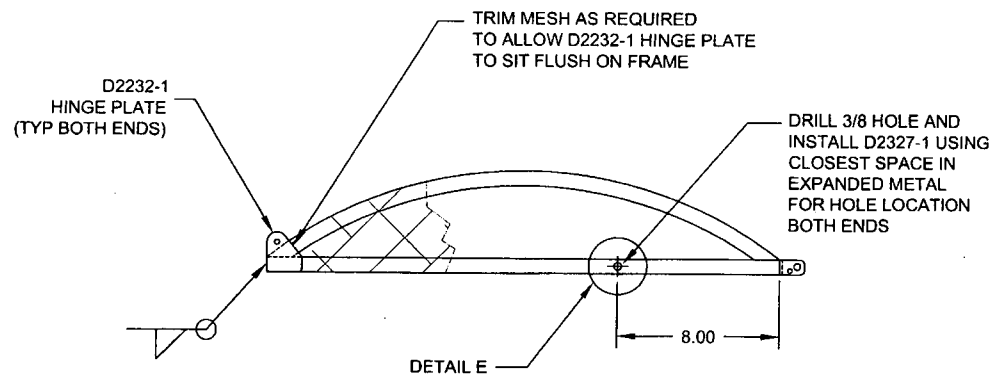
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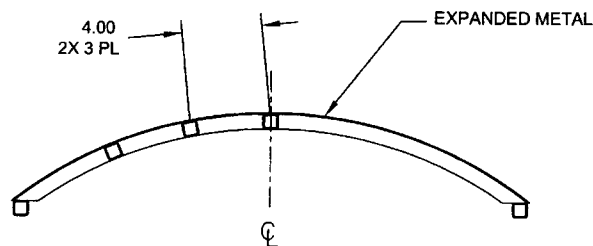
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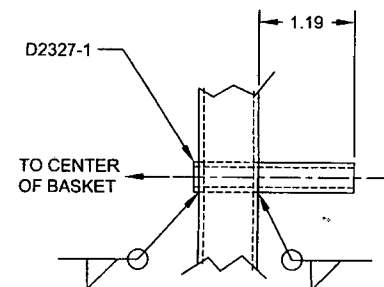
8 7 6 5 4 3 2 1



VIEW C-C SIMILAR BOTH END RIBS A5-2



SECTION D-D SAME BOTH CENTER RIBS A4-2



DETAIL E C6-4

wb 59377

RELEASED
08.06.17

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 4 OF 4
APPROVED		TITLE	SCALE
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8 7 6 5 4 3 2 1

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries